

DART AEROSPACE LTD	Work Order:	18758
Description: Doubler	Part Number:	D3140-301/-303
Dwg: D3140 Rev. B Page 6	Qty:	X 2 U Stack of 6
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	DA	03.01.29	X 2
2	MV	Cut blanks: 48.700" x 7.350" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify as D3140-301	DA	03.01.29	2
3	MV	Cut blanks: 48.700" x 7.250" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify as D3140-303	DA	03.01.29	2
4	MV GA	Machine D3140-301 as per Folio FA316 and Dwg D3140- form as per template D3140-303	DA	03.01.29	2
5	QC8	Inspect parts as they come off the CNC machine	DA	03.01.29	2
6	MV	Deburr	DA	03.01.29	2
7	QC8	Second inspection	N/A		
8	MV GA	Machine D3140-303 as per Folio FA316 and Dwg D3140- form as per template D3140-303	DA	03.01.29	2
9	QC8	Inspect parts as they come off the CNC machine	DA	03.01.29	2
10	MV	Deburr	DA	03.01.29	2
11	QC8	Second inspection	N/A		
12	FP	Chemical Conversion Coat D3140-301 & D3140-303 as per QSI 005 4.1	SO	03-01-30	2
13	QC3	Inspect Conversion Coat	DA	03.01.30	2
14	ST	Identify and Stock	DA	03.01.30	2
15	AC	Cost / part 52.98 52.98 50% to -301/-303	DA	03.01.31	2
16	DC	Close W/O 52.98 52.98 Inspect Level 21	DA	03.01.31	-

Rev	Date	Change	Revised By	Approved
A	02.11.06	New issue	KJ/RF R4	

RELEASED
03.01.29 FF